

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005668**Date Inspected:** 23-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Dan Hernandez was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 14 OBG Assembly

Segment 7CE

Submerged Arc Welding (SAW) of weld joint SEG038A-003 located on SP573A to SP613A. Welder is identified as 044755. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7CE

Submerged Arc Welding (SAW) of weld joint SEG038A-006 located on BP64A to BP118A. Welder is identified as 044755. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 1BE

Flux Cored Arc Welding (FCAW) of weld joint DP616-001-042, 052, 062, 072, 061, 051, 046, 031 located on Floor Beam Diaphragm X98G to DP616.

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## WELDING INSPECTION REPORT

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DP611-001-072, 062, 052, 042, 041, 051, 061, 071 located on Floor Beam Diaphragm X98F to DP611.

DP596-001-015, 020, 028, 036, 044, 052, 051, 043, 035, 027, 019, 014 located on Floor Beam Diaphragm X98F to DP596.

Welders are identified as 044801. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 13 OBG Assembly

Segment 1BE

Flux Cored Arc Welding (FCAW) of weld joint SEG006C-005 thru 020 located on LD30A to BP306A. Welders are identified as 051356 and 055491.

Flux Cored Arc Welding (FCAW) of weld joint SEG006B-005 thru 020 located on LD29A to BP308A. Welder is identified as 044774.

FCAW of weld joint SSD49-PP11.5-047 thru 064 located on FB56A to BP308A and BP304A and SSD49A-PP11.5-047 thru 064 located on FB56A to BP306A and BP304A. Welder is identified as 055491.

FCAW of weld joint SSD45-PP12.5-047 thru 064 located on FB58A to BP308A and BP304A and SSD45A-PP12.5-047 thru 064 located on FB58A to BP306A and BP304A. Welder is identified as 051356.

ZPMC QC is identified as Huang Shuai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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